



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G12131-3G
Job Sheet 176868



Part No: RBW6205G12131-3G

Job Qty: 6 ea

Part Name: Main Rotor Lever Tension Link Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/2/18

Job Tracking No:

Due Date: 5/25/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG RBW6205G12131-3G Rev 6 IPP Rev A 18.01.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	6 pcs		5/25/18	0.00	0.00	Purchasing Start Up		AT 18/06/18
105	Packaging	6 pcs		5/25/18	0.00	0.00	Packaging2		AT 18/06/18
115	QC	6 pcs		5/25/18	0.00	0.00	QC6		AT 18/06/18
125	Large Fab	6 pcs		5/25/18	0.00	3.00	Large Fab 1		AT 18/06/18
135	QC	6 pcs		5/25/18	0.00	0.00	QC9		AT 18/06/18
136	QC	6 pcs		5/25/18	0.00	0.00	QC5		AT 18/06/18
145	Small Fab	6 pcs		5/25/18	0.00	1.50	Small Fab-4		AT 18/06/18
155	QC	6 pcs		5/25/18	0.00	0.00	QC5		AT 18/06/18
165	Packaging	6 pcs		5/25/18	0.00	0.00	Packaging3-1		AT 18/06/18
175	QC21-FG	6 Ea		5/25/18	0.00	0.00	QC21		AT 18/06/18

Part Op 90 - Issue P/O: 39775 Supplier: WEJAY ***SEE DWG FOR REQUIRED QTY OF EACH PART*** MANUFACTURE;
Descriptions: RBW6205G12131-3G-3, RBW6205G12131-3G-5, RBW6205G12131-3G-7, RBW6205G12131-3G-11, RBW6205G12131-3G-13, RBW6205G12131-3G-15, RBW6205G12131-3G-17, RBW6205G12131-3G-19, RBW6205G12131-3G-21 AS PER DWG -Certificate of conformity is required

125 - Weld RBW6205G12131-3G-1 assembly using RBW6205G12131-3G-3, RBW6205G12131-3G-5, RBW6205G12131-3G-7. Weld RBW6205G12131-3G-9 assembly using RBW6205G12131-3G-11, RBW6205G12131-3G-13, RBW6205G12131-3G-15.

145 - 1-Fabricate lanyard as per DWG. 2-Assemble as per DWG. Sheet 1. 3-Cut -29, -31, -35 and -37 to fit as per note 2. 4-Assemble using RBW6205G12131-3G-21, -17, -19, -1, -9 as per DWG RBW6205G12131-3G.

MAY 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G12131-3GP	Main Rotor Lever Tension Link Tool	6 pcs (1 ea)	90-Purchasing	5077184
3896T31	Ferule 1/16 X 3/8" - Aluminum	12 Ea (2 ea)	145-Small Fab	5059248
8098K24	Heat Shrink Tubing	.3000 ft (.05 ea)	145-Small Fab	5069060
8583K61	Rubber w/ Adhesive Back 50A durometer	1.2780 sf (.213 ea)	145-Small Fab	5040833
8583K66	Rubber w/ Adhesive Back 30A durometer	1.1400 sf (.19 ea)	145-Small Fab	5042374
90905A651	SS Split Ring	12 Ea (2 ea)	145-Small Fab	5042320
90985A113	Knob Grip Quick release Pin	6 Ea (1 ea)	145-Small Fab	5009399
92196A341	TBD	12 (2 ea)	145-Small Fab	5069441
CL-2-C	Lanyard Wire	6.9600 ft (1.16 ea)	145-Small Fab	5076878
K010-0608	Hose Ø1/2 OD x Ø3/8 ID x 12-1/2ft	.9600 ft (.16 ea)	145-Small Fab	5053844

94932



Container No: S077185



Part: RBW6205G12131-3G

Job No: 176868

Serial No/Batch: S077185

Revision: 6

Inspector:

Exp Date: 06/01/2018

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/01/18

Job Allocations

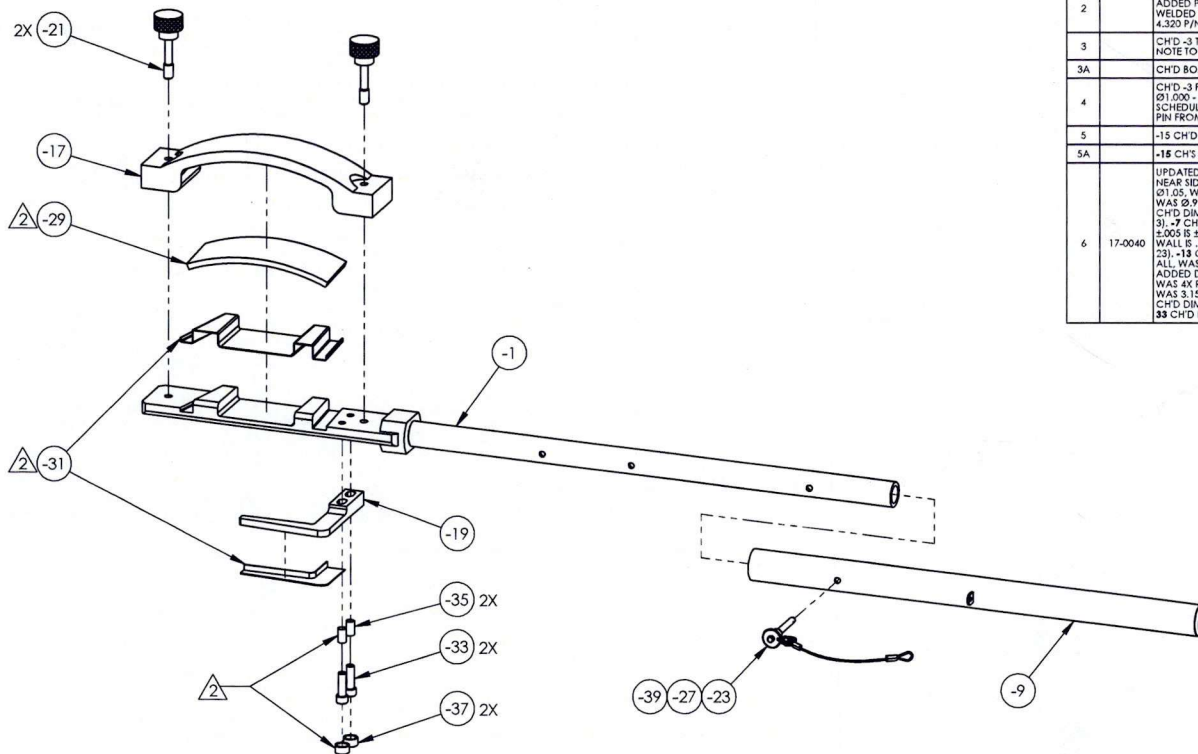
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing 145-Small Fab	RBW6205G12131-3GP	6	0	0
	3896T31	12	562	0
	8098K24	0	3	0
	8583K61	1	6	0
	8583K66	1	6	0
	90905A651	12	20	0
	90985A113	6	2	0
	92196A341	12	0	0
	CL-2-C	7	350	0
	K010-0608	1	376	0

Part Specifications

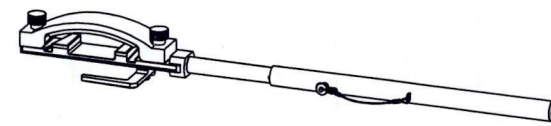
Specifications could not be found.

Plex 5/2/18 11:10 AM dart.lavoie.chantal

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.



REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		CHD LENGTH P/N-3 FROM 21.53, CHD LENGTH P/N-11 FROM 19.63 PER G.E. CORRECTED TAB P/N FROM -11 & EXTENSION P/N FROM -9.	9/22/2009	RJC		
2		CHD BOM P/N-29 LENGTH FROM 7, CHD P/N-33 LENGTH FROM 1-1/4, CHD P/N-35 INFORMATION, ADDED P/N-37 PER V.E. ADDED R.525 TO P/N-15 & EXTENDED LENGTH FROM .485 SO TAB CAD BE WELDED TO P/N-11. ADDED MISSING DIM. 388 P/N-7, CHD ANGLE FROM 74°, CHD DIM 4.345 TO 4.320 P/N-19 PER G.E.	10/29/2009	RJC	RW	
3		CHD -3 TO 1/2 SCHEDULE 80 & -11 TO 3/4 SCHEDULE 10, CHD -3 & -11 O.D. & I.D. PER D.W. ADDED NOTE TO -3 & -11 TO CLEAN UP SCRATCHES (BUFF) O.D. PER R.W.	2/17/2011	RJC	RW	
3A		CHD BOM -5 MATERIAL FROM RND. BAR Ø X 1-5/16.	9/20/2012	RJC	SE	
4		CHD -3 FROM 1/2in. SCHEDULE 80 TO 3/4in. SCHEDULE 80, CHD SMALL DIA. FROM Ø.830 S.F. TO Ø1.000-.998, CHD -5 HOLE FROM Ø.840 S.F. -3 TO Ø1.0045-1.0025, CHD -11 FROM 3/4in. SCHEDULE 10 TO 1in. SCHEDULE 10, CHD -13 OD FROM Ø.984 TO Ø1.250, CHD -23 QUICK RELEASE PIN FROM MCMASTER-CARR #90985A127 TO MCMASTER-CARR #90985A113.	12/4/2012	RJC	DW	
5		-15 CH'D DIM WAS .04 IS .075 UPDATED BOM.	2/4/2013	BIM	SE	
5A		-15 CH'S .075 DIMENSION TO CORRECT LAYER SO IT IS VISIBLE ON DWG	6/10/2014	DJN	RJC	
6	17-0040	UPDATED TO NEW STANDARD. -1 CHD DIM WAS (5.850) IS (5.944), CHD WELD NOTE WAS FILLET NEAR SIDE FAR SIDE ALL AROUND IS FILLET NEAR SIDE ALL AROUND. -3 CHD DIMS WAS (Ø1.050) IS (Ø1.05), WAS .154 WALL IS .15, WAS .50 IS .30, WAS 3X Ø.254 THRU IS 3X Ø.250-.254 THRU ALL (S.F. -23), WAS Ø.998-1.000 IS Ø.998-1.000 (S.F. -5), WAS 3.950 IS 3.95, WAS 7.870 IS 7.87, WAS 3.580 IS 3.58, -5 CHD DIMS WAS 1.063 IS 1.06, WAS .787 IS .79, WAS .523 IS .523 +.005-.000, WAS Ø1.0025-1.0045 (S.F. -3), -7 CHD DIMS WAS .388 IS 2X .388, WAS 2X .518 IS 2X .518 +.000-.005, -9 CHD TOLERANCES WAS ±.005 IS ±.010, WAS ±.01 IS ±.03, ADDED DIM (3.950), -11 CHD DIMS WAS (Ø1.315) IS Ø1.32, WAS .109 WALL IS .11, WAS 19.750 IS 19.75, WAS 3.950 IS 3.95, WAS Ø.250 THRU IS Ø.250-.254 THRU ALL (S.F. -23), -13 CHD DIMS WAS Ø1.250 IS Ø1.25, WAS 1.87 IS .19, -15 CHD DIMS WAS Ø.167 IS Ø.17 THRU ALL WAS .543 IS (.543), WAS .471 IS .47, WAS R.525 IS R.66, WAS R.236 IS R.24, WAS .075 IS .08, ADDED DIM .50, -17 CHD DIMS WAS 2X R.588 IS 2X R.59, WAS 2X 4.331 IS 4.331, WAS .994 IS 2X .994, WAS 4X R.375 IS 4X R.38 WAS (.463) IS .463, -19 CHD DIMS WAS 4.320 IS 4.32, WAS .394 IS 4X .394, WAS 3.150 IS (3.150), WAS R.188 IS R.19, DELETED DIM 2X Ø.354, ADDED DIMS 2X .354, 4X FULL R. -21 CHD DIMS WAS Ø1.181 IS Ø1.18, WAS Ø.787 IS Ø.79, WAS Ø.295 IS Ø.30, -28 DELETED FROM BOM. -38 CHD B/O REF WAS #92196A343 IS (#92196A341), -39 ADDED FERRULE TO BOM QTY 2.	2/13/2017	DPD	JAG	



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	HANDLE WELDMENT			2
	1		-3		HANDLE	SEAMLESS 304 S.S.		3
	1		-5		ATTACHMENT	304 S.S.		4
	1		-7		PLATE	304 S.S.		5
X			-9	1	EXTENSION HANDLE WELDMENT			6
	1		-11		EXTENSION	SEAMLESS 304 S.S.		7
	1		-13		END CAP	304 S.S.		8
	1		-15		TAB	304 S.S.		9
			-17		TOP	304 S.S.		10
			-19	1	FINGER	304 S.S.		11
			-21	2	KNOB	304 S.S.		12
B/O	-23	1			QUICK RELEASE PIN	S.S.	Ø1/4 X 1-1/2 USABLE (MCMASTER-CARR #90985A113)	1
B/O	-27	1			LANYARD	COATED STEEL	Ø1/16 X 14 (CARR LANE #CL-2-C)	1
B/O	-29	1			RUBBER WITH ADHESIVE BACK	RUBBER	1/4 X 2-1/4 X 6-1/2 (GASKET SPECIALTIES)	1
B/O	-31	1			RUBBER WITH ADHESIVE BACK	RUBBER	1/32 X 6 X 12 (GASKET SPECIALTIES)	1
B/O	-33	2			SOCKET HEAD CAP SCREW	S.S.	5/16-24 X 1 (MCMASTER-CARR #92196A341)	1
B/O	-35	2			SLEEVE	PLASTIC	Ø3/8 BLACK SHRINK TUBE (PACIFIC RUBBER)	1
B/O	-37	2			HOSE	PLASTIC	Ø3/8 I.D. X Ø1/2 O.D. (KURITEC #K010-0608)	1
B/O	-39	2			FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896131)	1
ASSY -9	ASSY -1							

NOTES:

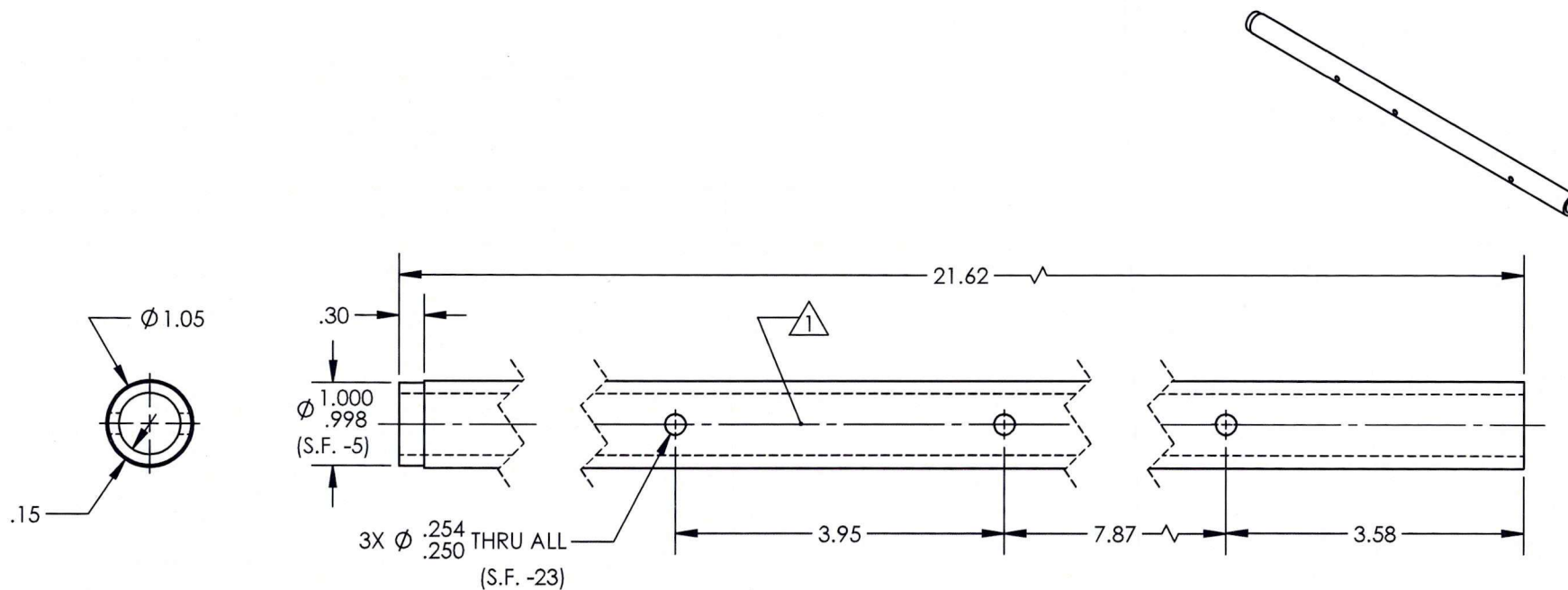
1. REF AGUSTA T/N: 3G6205G12131.

2. CUT TO FIT.

		TITLE	
		M/R LEVER TENSION LINK TOOL	
DWG NO.		REV	
RBW6205G12131-3G		6	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		XXX ± .005 FRACTIONS ± 1/8	
SPEC		XX ± .01 ANGLES ± 5°	
		X ± .1 SURFACES ± 125	
DRAWN BY: MARTINEZ		1. BREAK ALL SHARP EDGES	
CHECKED: RJC 02/13/2017		Ø15 X 45° OR .015R	
OPPS APPR: AA 02/28/2017		2. DIMENSIONAL LIMITS APPLY	
QA APPR: JL 02/28/2017		AFTER PLATING	
APPROVED: JAG 03/17/2017		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:5		DATE 1/12/2009	
		SHEET 1 OF 12	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CH'D -3 TO 1/2 SCHEDULE 80, CH'D -3 O.D. & I.D. PER D.W. ADDED NOTE TO -3 TO CLEAN UP SCRATCHES (BUFF) O.D. PER R.W.	2/17/2011	RJC	RW
4		CH'D -3 FROM 1/2in. SCHEDULE 80 TO 3/4in. SCHEDULE 80. CH'D SMALL DIA. FROM Ø.830 S.F. TO Ø1.000 - .998.	2/17/2011	RJC	RW
6	17-0040	-3 CH'D DIMS WAS (Ø1.050) IS Ø1.05, WAS .154 WALL IS .15, WAS .50 IS .30, WAS 3X Ø.254 THRU IS 3X Ø.250-.254 THRU ALL (S.F. -23), WAS Ø.998-1.000 IS Ø.998-1.000 (S.F. -5), WAS 3.950 IS 3.95, WAS 7.870 IS 7.87, WAS 3.580 IS 3.58.	2/13/2017	DPD	JAG



NOTE:

1 CLEAN UP SCRATCHES (BUFF) O.D.

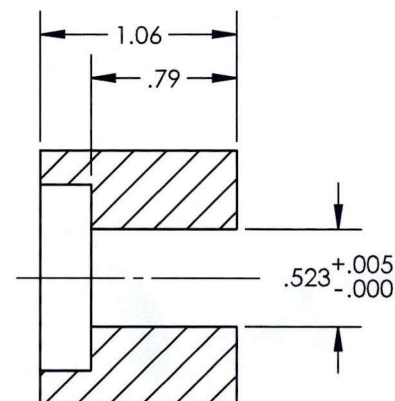
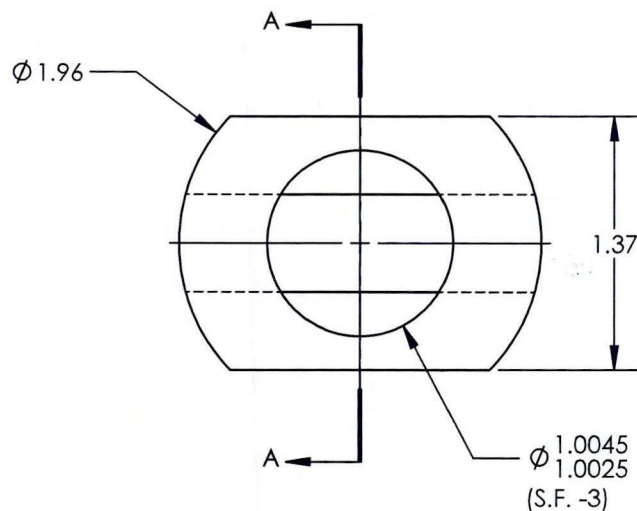
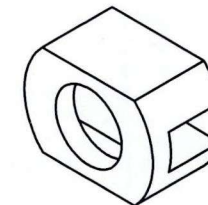
DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-3	REV 6
MAT'L SEAMLESS 304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MARTINEZ	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 02/13/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 02/28/2017	USED ON MODEL
QA APPR: JL 02/28/2017	AGUSTA
APPROVED: JAG 03/17/2017	
SCALE 1:2	DATE 1/12/2009 SHEET 3 OF 12

(-3)

HANDLE

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
4		CH'D -5 HOLE FROM Ø.840 S.F. -3 TO Ø1.0045 - 1.0025.	12/4/2012	RJC
6	17-0040	-5 CH'D DIMS WAS 1.063 IS 1.06, WAS .787 IS .79, WAS .523 IS .523 +.005-.000, WAS Ø1.0025-1.0045 (S.F. -3).	2/13/2017	DPD



SECTION A-A

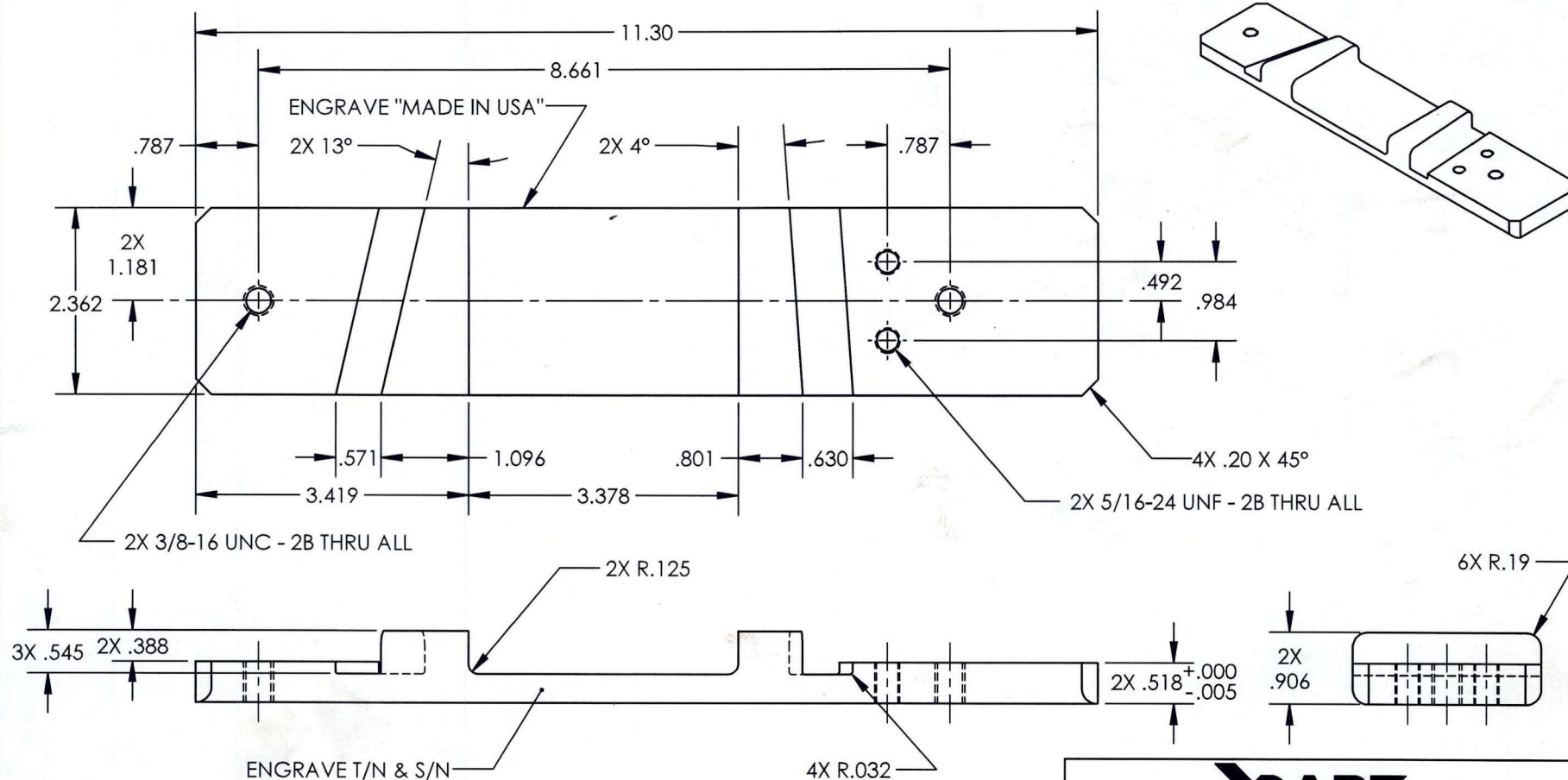
(-5)

ATTACHMENT

DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-5	REV 6
MAT'L 304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: MARTINEZ	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 02/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 02/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 02/28/2017	USED ON MODEL
APPROVED: JAG 03/17/2017	AGUSTA
SCALE 1:1	DATE 1/12/2009
SHEET 4 OF 12	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	17-0040	-7 CH'D DIMS WAS .388 IS 2X .388, WAS 2X .518 IS 2X .518 +.000-.005.	2/13/2017	DPD	JAG

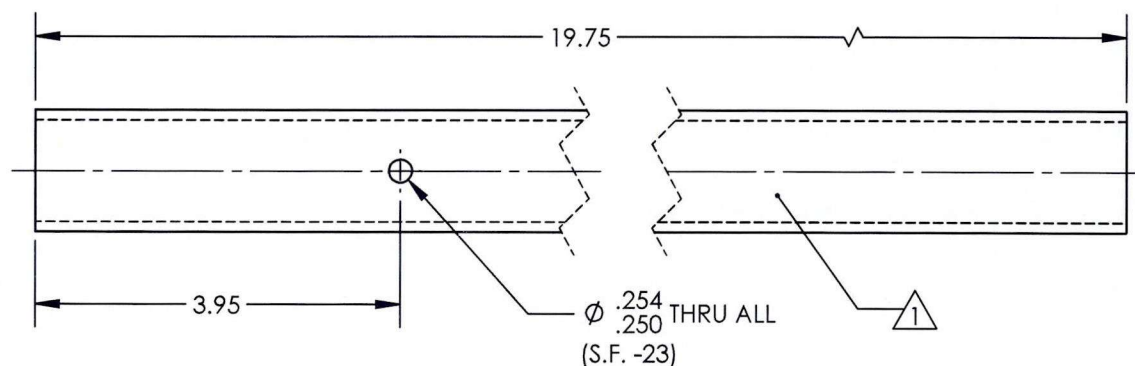
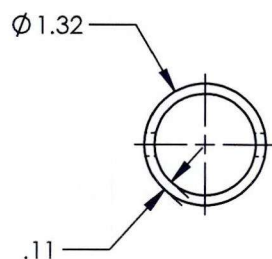


(-7)
PLATE

DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-7	REV 6
MAT'L 304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MARTINEZ	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 02/13/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 02/28/2017	USED ON MODEL
QA APPR: JL 02/28/2017	AGUSTA
APPROVED: JAG 03/17/2017	
SCALE 1:2	DATE 1/12/2009
SHEET 5 OF 12	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CH'D -11 TO 3/4 SCHEDULE 10, CH'D -11 O.D. & I.D. PER D.W. ADDED NOTE TO -11 TO CLEAN UP SCRATHES (BUFF) O.D. PER R.W.	2/17/2011	RJC	RW
4		CH'D -11 FROM 3/4in. SCHEDULE 10 TO 1in. SCHEDULE 10.	12/4/2012	RJC	DW
6	17-0040	-11 CH'D DIMS WAS (Ø1.315) IS Ø1.32, WAS .109 WALL IS .11, WAS 19.750 IS 19.75, WAS 3.950 IS 3.95, WAS Ø.250 THRU IS Ø.250-.254 THRU ALL (S.F. -23).	2/13/2017	DPD	JAG



NOTE:

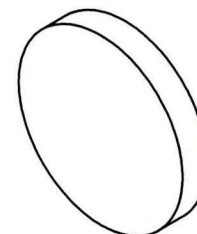
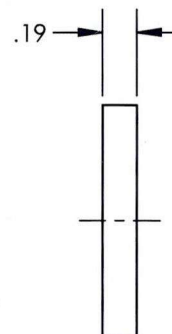
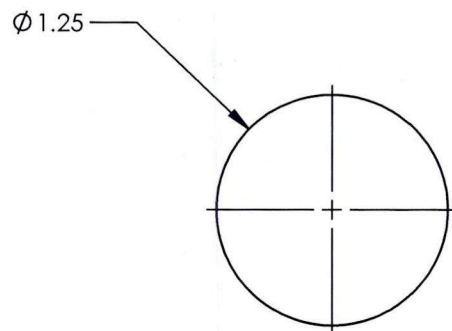
1 CLEAN UP SCRATHES (BUFF) O.D.

(-11)
EXTENSION

DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-11	REV 6
MAT'L SEAMLESS 304 S.S. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓	
SPEC	
DRAWN BY: MARTINEZ	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 02/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 02/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 02/28/2017	USED ON MODEL
APPROVED: JAG 03/17/2017	AGUSTA
SCALE 1:2	DATE 1/12/2009 SHEET 7 OF 12

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		CH'D -13 OD FROM Ø.984 TO Ø1.250.	12/4/2012	RJC	DW
6	17-0040	-13 CH'D DIMS WAS Ø1.250 IS Ø1.25, WAS .187 IS .19.	2/13/2017	DPD	JAG



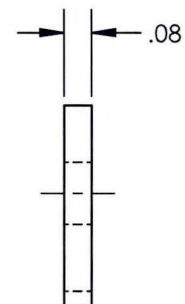
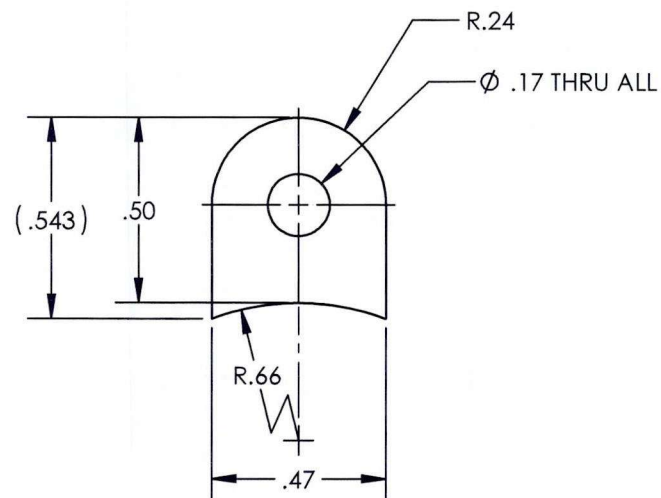
(-13)

END CAP

DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-13	REV 6
MAT'L 304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MARTINEZ	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 02/13/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 02/28/2017	USED ON MODEL
QA APPR: JL 02/28/2017	AGUSTA
APPROVED: JAG 03/17/2017	
SCALE 1:1	DATE 1/12/2009 SHEET 8 OF 12

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		CH'D DIM WAS .04 IS .075 AND UPDATED BOM.	2/4/2013	BIM	SE
5A		-15 CH'S .075 DIMENSION TO CORRECT LAYER SO IT IS VISIBLE ON DWG	6/10/2014	DJN	RJC
6	17-0040	-15 CH'D DIMS WAS Ø.167 IS Ø.17 THRU ALL, WAS .543 IS (.543), WAS .471 IS .47, WAS R.525 IS R.66, WAS R.236 IS R.24, WAS .075 IS .08. ADDED DIM .50.	2/13/2017	DPD	JAG



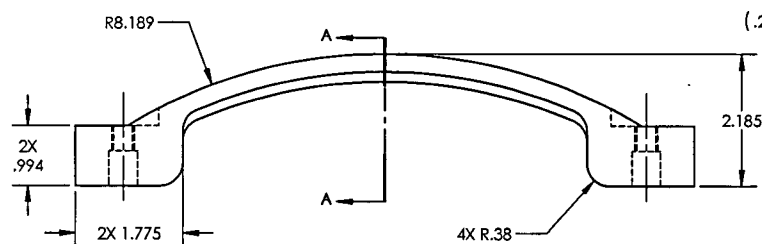
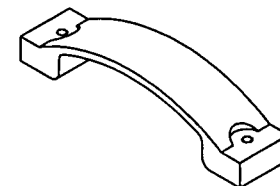
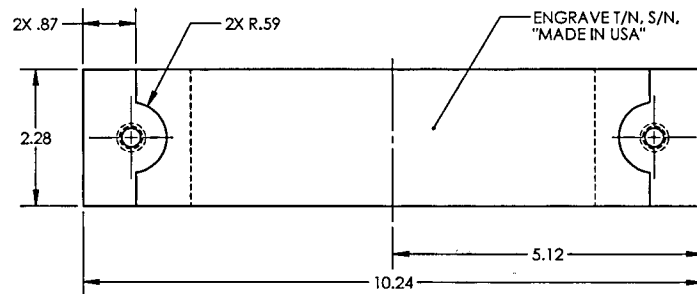
(-15)

TAB

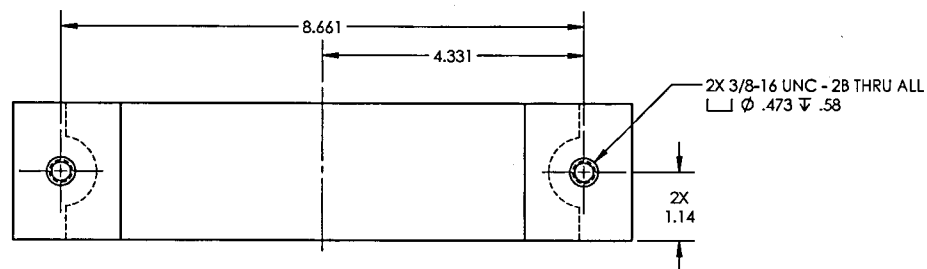
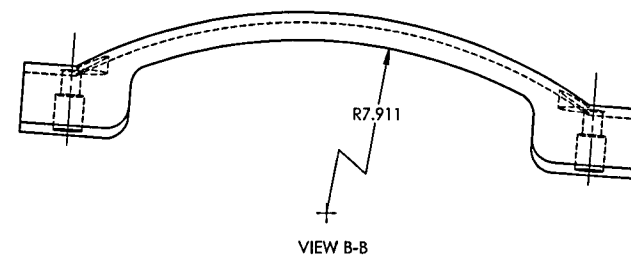
DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-15	REV. 6
MAT'L 304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: MARTINEZ	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 02/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 02/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 02/28/2017	USED ON MODEL
APPROVED: JAG 03/17/2017	AGUSTA
SCALE 2:1	DATE 1/12/2009
SHEET 9 OF 12	

The drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
6	17-0040	-17 CH'D DIMS WAS 2X R.588 IS 2X R.59, WAS 2X 4.331 IS 4.331, WAS .994 IS 2X .994, WAS 4X R.375 IS 4X R.38, WAS (.463) IS .463.	2/13/2017	DPD	JAG	



SECTION A-A



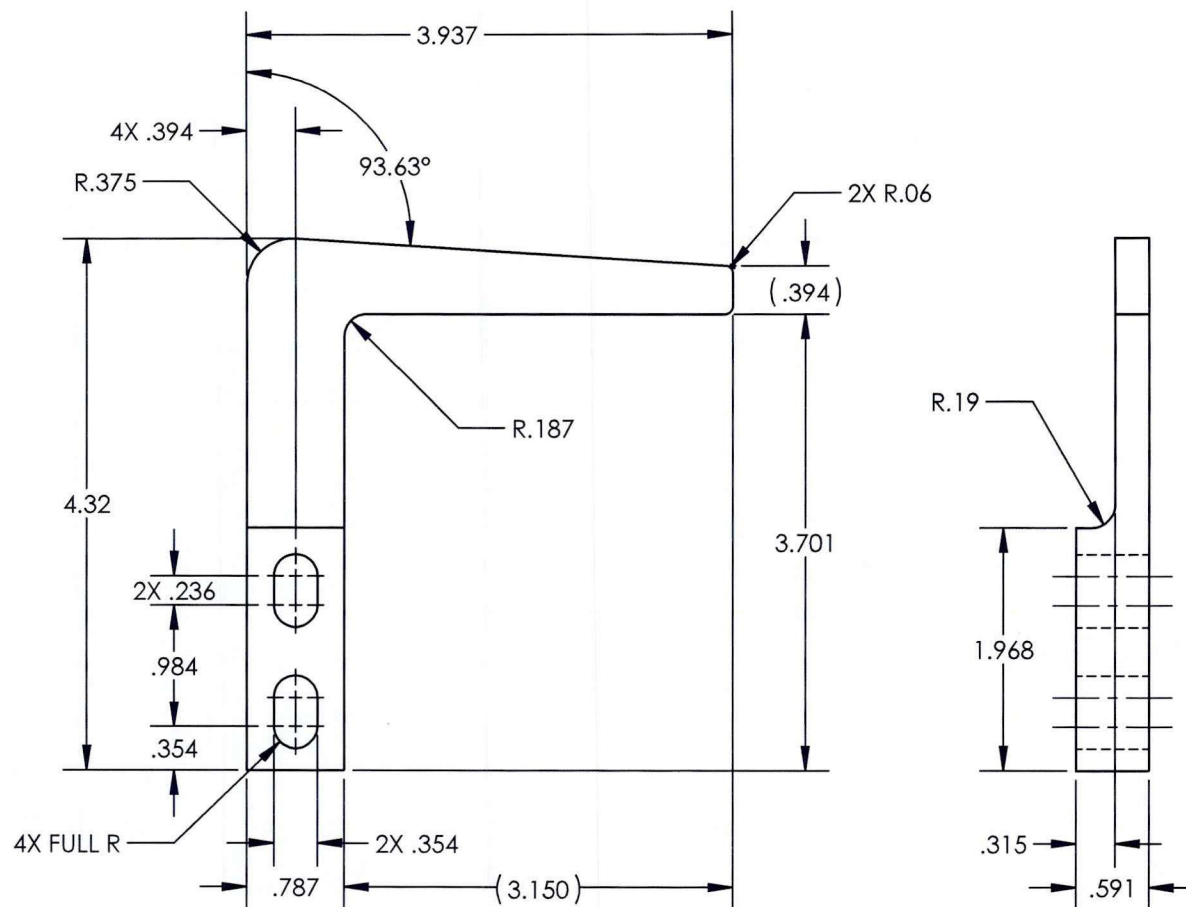
(-17)

TOP

DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-17	REV 6
MATL 304 S.S. FINISH TREAT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MARTINEZ CHECKED: RJC 02/13/2017 OPFS APPR: AA 02/28/2017 QA APPR: JL 02/28/2017 APPROVED: JAG 03/17/2017	
USED ON MODEL AGUSTA	
SCALE 1:2	DATE 1/12/2009 SHEET 10 OF 12

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
6	17-0040	-19 CH'D DIMS WAS 4.320 IS 4.32, WAS .394 IS 4X .394, WAS 3.150 IS (3.150), WAS R.188 IS R.19. DELETED DIM 2X Ø.354. ADDED DIMS 2X .354, 4X FULL R.			2/13/2017	DPD	JAG

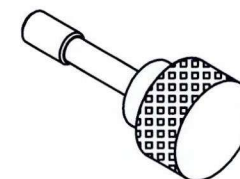
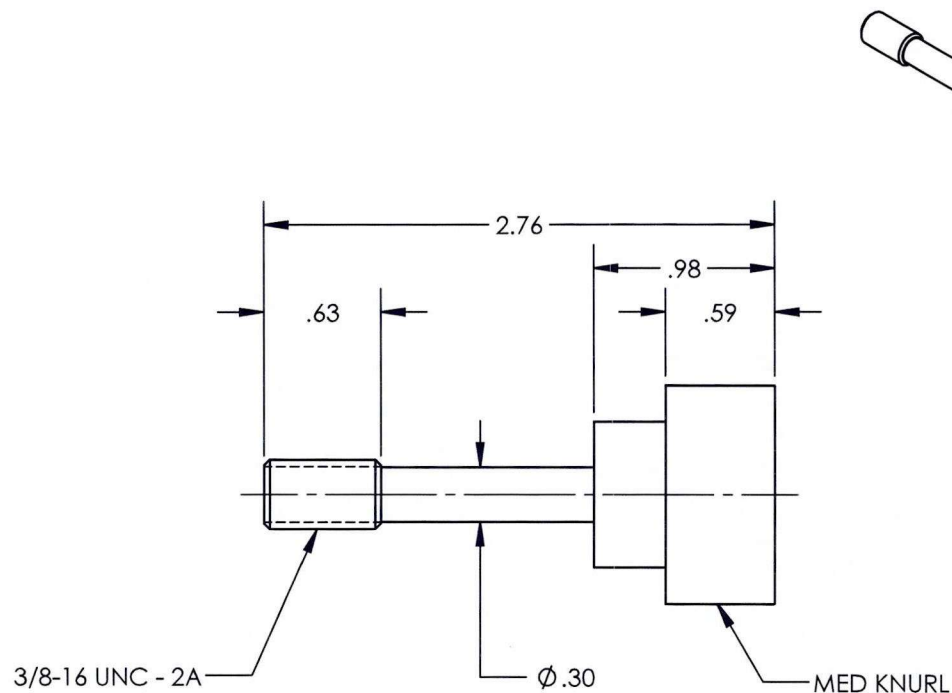
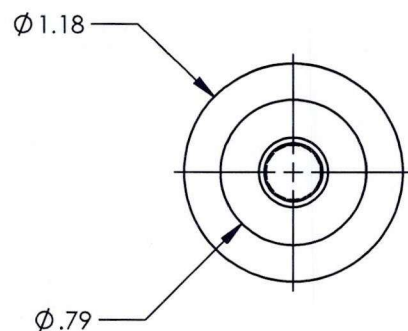


(-19)
FINGER

DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-19	REV 6
MAT'L 304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: MARTINEZ	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 02/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 02/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 02/28/2017	USED ON MODEL
APPROVED: JAG 03/17/2017	AGUSTA
SCALE 2:3	DATE 1/12/2009
SHEET 11 OF 12	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	17-0040	-21 CH'D DIMS WAS Ø1.181 IS Ø1.18, WAS Ø.787 IS Ø.79, WAS Ø.295 IS Ø.30.	2/13/2017	DPD	JAG



(-21)
KNOB

DART AEROSPACE	
TITLE M/R LEVER TENSION LINK TOOL	
DWG NO. RBW6205G12131-3G-21	REV 6
MAT'L 304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125°
DRAWN BY: MARTINEZ	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 02/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 02/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 02/28/2017	USED ON MODEL
APPROVED: JAG 03/17/2017	AGUSTA
SCALE 1:1	DATE 1/12/2009
SHEET 12 OF 12	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039775

Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO039775

PO Date: 5/2/18

Due Date: 5/25/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED

MAY 02 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: QUOTATION NO. WJ-9953

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBW6205G12131-3GP			Main Rotor Lever Tension Link Tool W/O 176868	Firmed	5/25/18	6 pcs	0 pcs	6 pcs	\$2,297.00/pcs	\$13,782.00

Line Item Note QUOTE INCLUDES COMPONENTS:
-3/-5/-7/-11/-13/-15/-17/-19 AND (2)

Grand Total: \$13,782.00

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/2/18 11:23 AM dart.lavoie.chantal



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace		DATE: May 31, 2018	
		P.O.# 039775	
		WEJAY JOB# 39107	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
Main Rotor Lever Tension Link Tool #RBW6205G12131-3G-3 Components as follows:			RBW6205G12131-3G / rev. 6
Part# -3 "Handle" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 3 of 12
Part# -5 "Attachment" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 4 of 12
Part# -7 "Plate" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 5 of 12
Part# -11 "Extension" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 7 of 12
Part# -13 "End Cap" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 8 of 12
Part# -15 "Tab" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 9 of 12
Part# -17 "Top" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 10 of 12
Part# -19 "Finger" ✓	6	Machined complete per drawing req'ts.	Dwg sheet 11 of 12
Part# -21 "Knob" ✓	12	Machined complete per drawing req'ts.	Dwg sheet 12 of 12
DAS 9 2-89 18-06-01			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory